



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM642V4001102
Job Sheet 173760



00317L

Part No: RBEM642V4001102

Job Qty: 1 ea

Part Name: Tail Rotor Head Damper Setting Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 5/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM642V4001102 REV 2 IPP REV A 18.03.05 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/9/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	1 pcs		5/10/18	0.08	0.25	Small Fab-9		MLC
110	QC	1 pcs		5/10/18	0.00	0.00	QC5		MLC
130	Packaging	1 pcs		5/10/18	0.00	0.00	Packaging3-2		MLC
140	QC21-FG	1 Ea		5/10/18	0.00	0.00	QC21		MLC

Part Op 100 - Assemble

Descriptions: 130 - Identify and Stock

21 MAY 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	90-Start up Operation	3016493
90128A249	Socket Head Cap Screw M5 x 0.8 x 25mm	2 Ea (2 ea)	100-Small Fab	3050218
90327A157	Socket Head Cap Screw M8 x 1.25 x 20mm	4 Ea (4 ea)	100-Small Fab	3050295
91595A446	Dowel Pin	4 Ea (4 ea)	100-Small Fab	3004179
92005A218	Pan Head Screw M4 x 0.7 x 8mm	2 Ea (2 ea)	100-Small Fab	3050296
CL-129-TAB-A	Cable Tab	2 (2 ea)	100-Small Fab	3063331
CL-2-C	Lanyard Wire	1.3300 ft (1.33 ea)	100-Small Fab	3026878
RBEM642V4001102-1	Base Plate	1 Ea (1 ea)	100-Small Fab	3050251
RBEM642V4001102-15	Wrench Weldment	1 Ea (1 ea)	100-Small Fab	3069253
RBEM642V4001102-3	Post	1 Ea (1 ea)	100-Small Fab	3069199
RBEM642V4001102-5	Post 2	1 Ea (1 ea)	100-Small Fab	3069215
RBEM642V4001102-7	Block	1 Ea (1 ea)	100-Small Fab	3067772
RBEM642V4001102-9	Knob Weldment	2 Ea (2 ea)	100-Small Fab	3069568

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	2	602	0
100-Small Fab	90128A249	2	0	0
	90327A157	4	0	0
	91595A446	4	19	0
	92005A218	2	0	0
	CL-129-TAB-A	2	0	0
	CL-2-C	1	463	0
	RBEM642V4001102-1	1	0	0
	RBEM642V4001102-15	1	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Engineering ☐ Quality ☐ Other ☐																																																						
Date : _____		Step #: _____		MRB (QSI042) Approval																																																						
Description Work Order Deviation				Completed By																																																						
				Lead hand / Supervisor Approval Verification																																																						
				QC / QA Coordinator Approval																																																						
Root Cause <table border="1" style="width: 100%; border-collapse: collapse;"><tr><td style="width: 50%;">Environment ☐</td><td style="width: 50%;">No Re-verification ☐</td></tr><tr><td>Design ☐</td><td>Operator ☐</td></tr><tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr><tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr><tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr><tr><td>Material ☐</td><td>Use for Testing ☐</td></tr><tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr><tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr><tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr><tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr><tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr><tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr></table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table border="1" style="width: 100%; border-collapse: collapse;"><tr><td style="width: 50%;">Pressure/Forced ☐</td><td style="width: 50%;">Ter ☐</td></tr><tr><td>Bending ☐</td><td>Set ☐</td></tr><tr><td>Centre Not Concentric ☐</td><td>BOI ☐</td></tr><tr><td>Cracks ☐</td><td>Bro ☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Insp ☐</td></tr><tr><td>Cuffs ☐</td><td>Con ☐</td></tr><tr><td>Crushing ☐</td><td>Cou ☐</td></tr><tr><td>Heat Treat ☐</td><td>Cut ☐</td></tr><tr><td>Wave/Twist in Tube ☐</td><td>Instructions Incomplete/Unclear ☐</td></tr><tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td></tr></table>		Pressure/Forced ☐	Ter ☐	Bending ☐	Set ☐	Centre Not Concentric ☐	BOI ☐	Cracks ☐	Bro ☐	Crimp/Kink/Ripple/Wave ☐	Insp ☐	Cuffs ☐	Con ☐	Crushing ☐	Cou ☐	Heat Treat ☐	Cut ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Marks/Chatter ☐	Drill Holes ☐	Date: 05/11/18 Container No: S070790 Part: RBEM642V4001102 Job No: 173760 Serial No/Batch: S070790 Revision: 2 Inspector: _____ DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com <table border="1" style="width: 100%; border-collapse: collapse;"><tr><td style="width: 33%;">Mislabeled ☐</td><td style="width: 33%;">Finish ☐</td><td style="width: 33%;">Drawing ☐</td></tr><tr><td>Fit/Function ☐</td><td>Misread ☐</td><td></td></tr><tr><td>Misaligned/off center ☐</td><td>Turning Sequence ☐</td><td></td></tr></table>		Mislabeled ☐	Finish ☐	Drawing ☐	Fit/Function ☐	Misread ☐		Misaligned/off center ☐	Turning Sequence ☐	
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RBEM642V4001102-3	1	0	0
RBEM642V4001102-5	1	0	0
RBEM642V4001102-7	1	0	0
RBEM642V4001102-9	2	0	0

Part Specifications

Specifications could not be found.

Plex 3/7/18 7:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By:					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			